

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001396**Date Inspected:** 26-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower Mock-up**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Bay II

Tower Mock-up 77 M

The QA inspector observed ZPMC performing backgouging operations at the outside of the corner connection skin A and E.

Tower 33 Meters Elevation

The QA inspector observed ZPMC performing heat straightening operations on the diaphragm plate p283. The QA inspector performed random verifications of ZPMC heat straightening operations. The QA inspector observed that ZPMC heat straightening operations appeared to be in accordance with the Contract documents.

Tower Splice 114 M Mock-up upper and lower segment.

The QA inspector observed that ZPMC was performing drilling operations on the skin D and B.

Tower Shop

The QA inspector observed ZPMC welding operator Jiang Jigteng welder ID # 046830 performing welding operations at the exterior of the joint skin C and D corner connection with the submerged arc welding(SAW)process. ZPMC's welding operations appeared to be in compliance with the contract document.

OBG Bay # III

The QA inspector observed ZPMC performing tack welding operations with the flux cored arc welding process at the bottom plate BP-020-001, Panel PL-49A, weld joints BP-020-001-023 and 024.

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OBG Bay # VII

The QA inspector observed ZPMC welder Wu Wan Yong performing welding operations with the flux cored arc welding at the floor beam weld joint FB-003-01-012 and FB-003-02-003BP-020-001 (stiffeners to web). The QA inspector performed random fit-ups and welding parameters verifications. The QA inspector found that ZPMC welding operations appeared to be in compliance with the contract documents.

Summary of Conversations:

The QA inspector did not have any relevant conversation on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
